

# Work Order ID 85096

\*85096\*

Page 1

June-01-12 3:43:11 PM

Item ID: D350-589-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Side Door Latch Modification

Stop \*NS2\*

Start Date: 01/06/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/09

Tooling:

Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
INN-D350-589	E								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type label as per PPP D350-589-011 CHG002								
105	Pick Kit	0.00							
<b>*105*</b>									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
15  
9/8/09

12/06/09

4x MLJ 12-8-8



4x

SP 12-8-8

DAS  
15  
9/8/09

12/06/09

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85096**

June-01-12 3:43:11 PM

**\*85096\***

Page 2

Item ID: D350-589-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Side Door Latch Modification

Start Date: 01/06/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

Rev A 122

12/8/13 AJ

R12-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-01-12 3:43:15 PM

Page 1

Work Order ID: 85096

\*85096\*

Parent Item: D350-589-011

\*D350-589-011\*

Parent Item Name: Side Door Latch Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F02.08.29Removed D2587 PlugKJ  
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	12			
<i>Sym</i> *AN960.ID10*									**	m/22378 SP			
Washer													
D2237		Manufactured	No			105	Each	56.0000	3	12			
<i>Sym</i> *D2237*									**	B64426 2x. SP			
Striker Plate										B.			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST006			56					
					66139			1					
					82062			15		3x			
					83376			40		7x			
D2583		Manufactured	No			105	Each	27.0000	3	12			
<i>Sym</i> *D2583*									**	SP			
Latch Bracket													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST011			27					
					82070			3					
					83445			24		12x			
D2585		Manufactured	No			105	Each	24.0000	3	12			
<i>Sym</i> *D2585*									**	B82029 8x			
Mounting Channel										SP 12-8-8.			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
					ST011			24					
					73297			2					
					83369			22		4x			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-01-12 3:43:15 PM

Page 2

Work Order ID: 85096

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

\*85096\*

\*D350-589-011\*

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2586

Manufactured No

105

Each

19.0000

\*D2586\*

Door Latch

Location

Loc Qty

Loc Code

ST203A

19

78833

19

Manufactured No

105

Each

27.0000

D2587

\*D2587\*

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST011

27

74522

1

78893

26

Manufactured No

105

Each

0.0000

D2589

\*D2589\*

Keys, Key Chain, 350 Hinge

MS20470AD4-5

Purchased No

105

Each

1,494.000

\*MS20470AD4-5\*

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1494

118405

483

120142

1011

\*\* 3 12  
B57917 IX. SP.  
B83893 11 K

\*\* 0 4  
SP

\*\* 0 4  
4A  
B 5894 SP

\*\* 6 24  
SP 12-8-8  
7

24K

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-01-12 3:43:15 PM

Page 3

Work Order ID: 85096

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

\*85096\*

\*D350-589-011\*

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

105

Each

2,195.000

12

\*MS21042L3\*

Nut

\*\*

m122141 SP

Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

MS27039-1-15

Purchased

No

105

Each

47.0000

12

\*MS27039-1-15\*

Screw

\*\*

m1224595x

SP 12-8-8.

Location

Loc Qty

Loc Code

ST291

47

118574

2

119736

1

121243

44

7x.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
<del>3</del>	<del>3</del>	<del>3</del>	<del>3</del>	<del>D2237</del>	<del>Striker Plate</del>
<del>1</del>	<del>1</del>	<del>1</del>	<del>1</del>	<del>D2464-1700</del>	<del>Seal</del>
<del>3</del>	<del>1</del>	<del>1</del>	<del>1</del>	<del>D2583</del>	<del>Latch Bracket</del>
<del>3</del>	<del>3</del>	<del>3</del>	<del>3</del>	<del>D2585</del>	<del>Latch Clamp</del>
<del>3</del>	<del>3</del>	<del>3</del>	<del>3</del>	<del>D2586</del>	<del>Latch</del>
<del>1</del>	<del>1</del>	<del>1</del>	<del>1</del>	<del>D2587</del>	<del>Plug</del>
<del>1</del>	<del>1</del>	<del>1</del>	<del>1</del>	<del>D2589</del>	<del>Keys, Key Chain</del>
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
<del>3</del>	<del>3</del>	<del>3</del>	<del>3</del>	<del>AN960JD10</del>	<del>Washer</del>
<del>3</del>	<del>9</del>	<del>9</del>	<del>9</del>	<del>MS21042L3</del>	<del>Nut (or MS21042-3)</del>
<del>6</del>	<del>6</del>	<del>6</del>	<del>6</del>	<del>MS20470AD4-5</del>	<del>Rivet</del>
<del>3</del>	<del>3</del>	<del>3</del>	<del>3</del>	<del>MS27039-1-15</del>	<del>Screw</del>

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.